

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013791**Date Inspected:** 15-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed visual inspection and dimensional checks on weld access cope holes on OBG 9DE. The following locations exhibited radii edge appears to comply with the contract documents. Reports forwarded to team leader for further action.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed visual inspection and dimensional checks on vertical stiffener above the longitudinal diaphragm on OBG 9DE. Reports forwarded to team leader for further action.

OBG # TRIAL ASSEMBLY YARD

This QA inspector performed dimensional check on floor beam using 1.5M straight edge to check flatness for below segment. Reports forwarded to team leader for further action

7AW-PP48 and PP49

7BW-PP50, PP51 and PP52

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (7CE)

SMAW Process:

Welding of weld joint – 004 located on PCMK CA039, corner assembly longitudinal weld joining Edge and Deck panel at E5 location. Welder is identified as 05087. Welding was been performed against critical welding repair report B-CWR1227 R-3. ZPMC CWI is identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (7AW-7BW)

SMAW Process:

Welding of weld joint – 031 located on PCMK SP429-001, Side panel I-Rib weld joins segment 7AW and 7BW. Welder is identified as 054467. ZPMC CWI is identified as Li Yang. Welding was been performed against welding repair report B-WR11909. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G (3F)-FCM-Repair-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
